

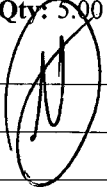
Work Order ID 163786

Monday, July 10, 2017 11:51:35 AM

163786

Page 1

Item ID: D2896-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Support
 Start Date: 7/13/2017 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 7/21/2017 Req'd Qty: 5.00 ***5*** Customer:

Reference:
 Approvals: Process Plan:  Date: JUL 11 2017 Tooling: Date:
 QC: Date: SPC (Y/N): Date:
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2896	C

100	HAAS CNC VERTICAL MACHINING #1	2.17							DAS 39
-----	--------------------------------	------	--	--	--	--	--	--	-----------

100 HAAS 1
 HAAS CNC vertical machine #1
 Memo Machine as per Folio FA167
 Folio Rev: AA
 Dwg Rev: C
 6 17-07-25

Deburr
 ****Program Batch #*****

110	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS 39
-----	---	------	--	--	--	--	--	--	-----------

110 QC
 Quality Control
 Memo
 6 17-07-25

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval																																																								
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____	
Misidentified ☐	Past Due ☐																																																														

163786

Monday, July 10, 2017 11:51:36 AM

Accept

N900040100

Setup Start *NIS1*

Stop *NS2*

Start Date: 7/13/2017 **Start Qty:** 5.00 ***5***

Cust Item ID:

Required Date: 7/21/2017 **Req'd Qty:** 5.00 ***5***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------------	---------------	------------------	----------------

120

QC8- Inspect parts - second check

0.00

120

OC

Memo

0.10

Quality Control

130

Identify as per dwg & Stock Location:_____

0.00

130

Packaging

Memo

0.05

Packaging

LOCATION : LG051

DAS
41
9-89

JUL 31 2017

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.50

Quality Control

17/8/2017

JUL 31 2017

M

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Picklist Print

Monday, July 10, 2017 11:51:34 AM

Page 1

Work Order ID: 163786

163786

Parent Item: D2896-1

D2896-1

Parent Item Name: Support

Start Date: 7/13/2017

Required Date: 7/21/2017

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP: B02.11.26Reformat; Added P/O; Added mask holeKJ

IPP Rev:C As per Rev B 07-04-16 JLM

IPP D 08.03.19 Re-format EC verified by DD

IPP REV:E

11.10.03 ASPER REV.C DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK080		Manufactured	No			100	Each	8.0000	0.5	2.5			DAS
DSK080									**				39
D2896-1 Turning Detail													9-89
											<u>3</u>	<u>17-07-27</u>	

Location

Loc Qty

Loc Code

MAT060

8

149288

3

157214

5

3

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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00

DART AEROSPACE LTD		Work Order:	163786
Description: Support		Part Number:	D2896-1
Inspection Dwg: D2896	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions						
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5	6	
HAAS Section										
AA	2.152	2.172		2.168	2.166	2.170	2.164	2.168	2.167	
AB	2.340	2.360		2.351	2.350	2.346	2.346	2.349	2.350	
AC	3.550	3.560		3.555	2.355	2.354	2.354	3.356	3.356	
AD	3.770	3.790		3.780	3.779	3.777	3.777	3.778	3.780	
AE	0.065 x 0.315	0.085 x 0.335		0.075 x 0.320	0.075 x 0.320	0.075 x 0.320	0.075 x 0.320	0.075 x 0.320	0.075 x 0.320	
AF	1.42	1.48		1.450	1.449	1.445	1.446	1.451	1.447	
AG	0.833	0.853		0.843	0.844	0.843	0.843	0.844	0.843	
AH	0.240	0.260		0.250	0.250	0.250	0.250	0.250	0.250	
AI	0.261	0.266		0.261	0.261	0.261	0.261	0.261	0.261	
AJ	0.189	0.194		0.190	0.190	0.190	0.190	0.190	0.190	
AK	1.970	2.030		2.004	2.006	2.0025	2.006	2.003	2.004	
AL	0.625	0.630		0.626	0.626	0.626	0.626	0.626	0.626	
AM	101.75	105.75		103.75	103.75	103.75	103.75	103.75	103.75	
AN	0.053	0.073		0.063	0.063	0.063	0.063	0.063	0.063	
AO	0.926	0.946		0.937	0.938	0.939	0.937	0.940	0.938	
AP										
AQ										
AR										

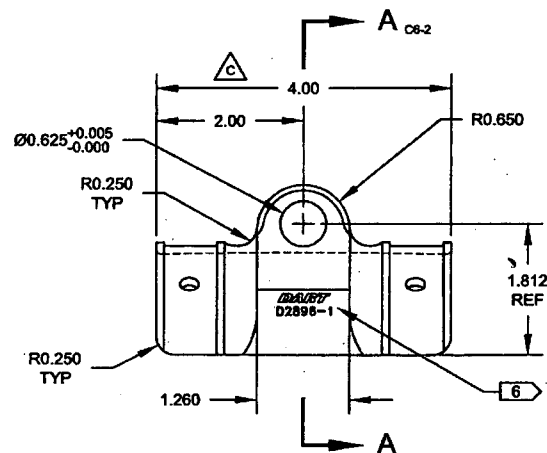
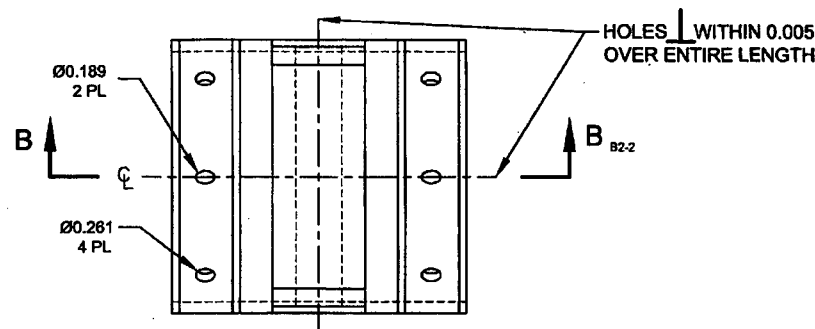
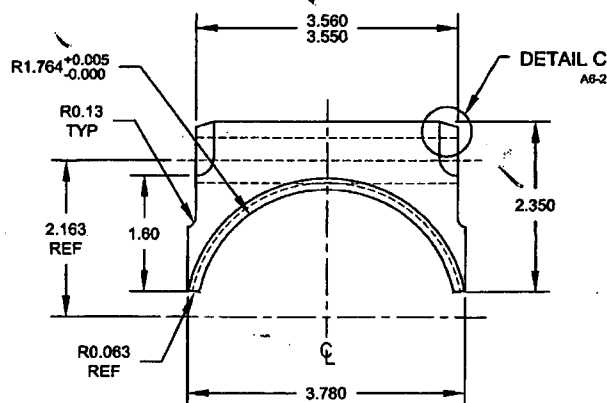
Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.005"

Accept/Reject	004	0015	0005	003	000	0005
Measured by:	39 DAS		Date: 17-07-25			
Audited by:	44 DAS		Date: 17-07-30			
Preliminary Approval:			Date:			

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	04.05.27	Dimension AE changed	KJ/RF	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	07.04.16	Dimsheet updated per Dwg Rev. B	KJ/JLM	
E	08.04.22	Reformat	KJ/JLM	
F	12.07.31	Dimensions updated per Dwg Rev C	KJ	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED CO
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 163786 *NP*

JUL 11 2017



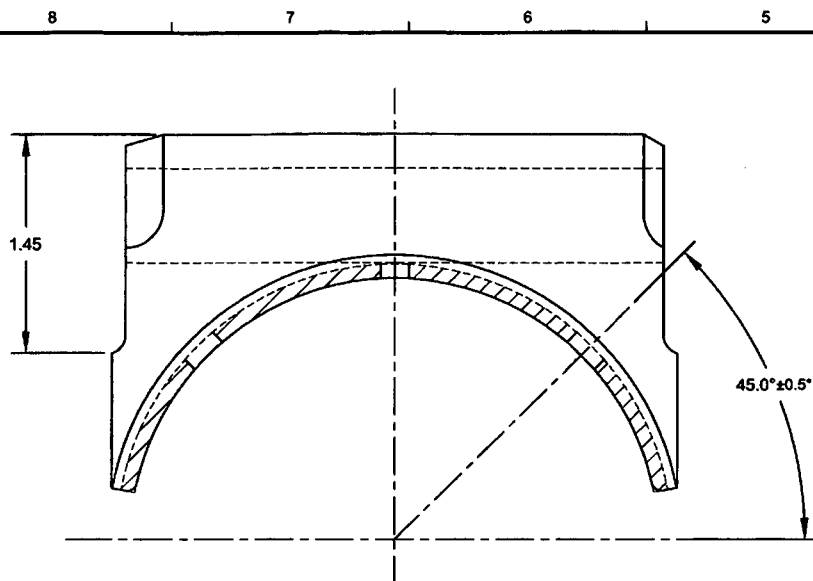
D2896-1 SUPPORT

RELEASED
2011-09-29

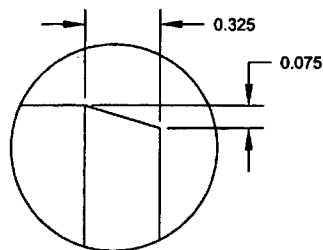
NOTES:

- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION
PER ASTM A564 OR AMS 5643 OR AISI 630
MIN UTS = 170 KSI (38 HRc)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO AND P/N WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP PER DART QSI 044 6.3
- 7) WEIGHT: 1.76 lbs

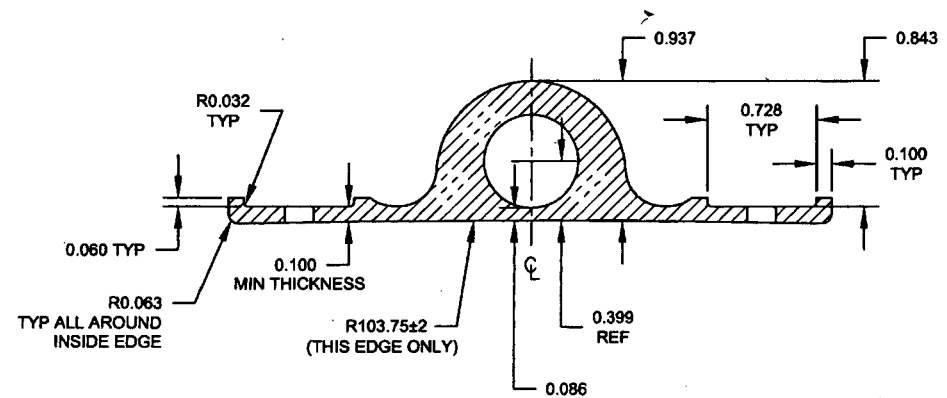
C	RMV FINISH & UPDATE MAT'L SPEC (A8-1), 2.00 WAS 2.000, 4.00 WAS 4.000 (C4-1), REFORMAT DWG	CP	11.09.07
B	INCORP. A1-A4, FINISHING NOTES	PH	07.03.19
A	NEW ISSUE	CP	01.10.19
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SECTION A-A C3-1
TOOLING HOLE DETAIL
SCALE 2X



DETAIL C C6-1
SCALE 4X



SECTION B-B D3-1
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